

Work Order ID 65806

Wednesday, January 26, 2011 10:54:35 AM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 11-01-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002 5/10/14

11-02-10

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/2/11 5/90

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

5/10/14

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65806

Page 2

Wednesday, January 26, 2011 10:54:35 AM

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Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011

Location: 22PPP Rev: C

11/2/14

(40)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/02/14

U 11.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, January 26, 2011 10:54:40 AM

Page 1

Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	----------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

88.0000

2

8



Screw

Location

Loc Qty

Loc Code

ST328

88

113064

1

113749

1

116304

86

AN526C832R8

Purchased

No

120

Each

100.0000

8

132



Screw

Location

Loc Qty

Loc Code

ST327

100

116471

100

AN526C832R9

Purchased

No

120

Each

343.0000

8

32



Screw

Location

Loc Qty

Loc Code

ST327

343

116419

43

116471

100

116540

200

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD10 NAS1149D0363J Purchased No

120 Each

8.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST 6

107715 6

ST335 2

105792 2



M116007 11/2/11

M116025 5X

AN960JD8 NAS1149DN832J Purchased No

120 Each

10.0000

24

96



Washer

Location

Loc Qty

Loc Code

ST347 10

105059 10



M116805 11/2/11

D2143 Manufactured No

120 Each

40.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST198 40

63505 1

64308 39



11/2/11

D2144 Manufactured No

120 Each

30.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST198 30

55179 6

64778 24



11/2/11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

S.M. D2150
Packer Doubler, Hinge

Manufactured No

120 Each

29.0000

2

8

Location

Loc Qty

Loc Code

ST007

29

64764

29

S.M. D2151
Packer Doubler, Hinge

Manufactured No

120 Each

37.0000

2

8

Location

Loc Qty

Loc Code

ST007

37

64310

3

64776

34

S.M. D2153
Door Prop

Manufactured No

120 Each

51.0000

1

4

Location

Loc Qty

Loc Code

ST272

51

64311

15

64943

36

S.M. D2154
Stud Bracket

Manufactured No

120 Each

44.0000

1

4

Location

Loc Qty

Loc Code

ST007

44

64312

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2237 Manufactured No

120 Each

62.0000 2

Striker Plate

Location

Loc Qty

Loc Code

ST009

62

64426

22

64762

40

D2461 Manufactured No

120 f

325.2300 7.25

Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

325.2300105

39782

6.5

55054

0.00001053

63880

318.73

cut 1 X 87.00"

D2463 Manufactured No

120 f

487.6005 7.25

Seal

Location

Loc Qty

Loc Code

S1404

487.60053

55561

1.68

62597

0.00053

64944

485.92

cut 1 X 87.00"

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2583

Manufactured No

120

Each

24.0000

2

8

Spm
Latch Bracket

Location

Loc Qty

Loc Code

ST017

23

64775

23

ST018

1

56527

1

D2585

Manufactured No

120

Each

44.0000

2

8

Spm
Mounting Channel

Location

Loc Qty

Loc Code

ST

3

64655

3

ST017

41

64761

41

D2586

Manufactured No

120

Each

60.0000

2

8

Spm
Door Latch

Location

Loc Qty

Loc Code

ST204

60

64656

60

D2587

Manufactured No

120

Each

20.0000

1

4

Spm
Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST018

20

64314

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2589 1
Keys, Key Chain, 350 Hinge

Manufactured No 120 Each 111.0000

Location Loc Qty Loc Code
ST019 111

58194

111

120 Each 10.0000

10.0000

Location Loc Qty Loc Code
ST021 10

64786

10

120 Each 14.0000

14.0000

D2857-1
Hinge Bracket

Manufactured No

Location Loc Qty Loc Code
ST026 14

64435

14

120 Each 23.0000

23.0000

D2857-2
Hinge Bracket

Manufactured No

Location Loc Qty Loc Code
ST027 23

57925

3

64463

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2858-1 Manufactured No

120 Each

26.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST027

26

63695

2

64785

24

D2858-2 Manufactured No

120 Each

24.0000

1

4



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

24

64787

24

FG-778150-550-ROL Purchased No

120 sf

1,618.150

1

4



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

ST404

1618.15

108932

18

111166

397

113905

1203.15

1- cut 1 square ft of glass cloth

MS20426AD3-4 Purchased No

120 Each

5,505.000

12

48



RIVET

Location

Loc Qty

Loc Code

ST316

5505

104374

1505

110398

4000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 65806

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5

Purchased

No

120

Each

1,262.000

18

72



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1262

116410

1262

120

Each

382.0000

18

72

MS21042L08

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

301

116471

1

116513

300

ST301

81

116549

81

MS21042L3

Purchased

No

120

Each

3,059.000

4

16



Nut

Location

Loc Qty

Loc Code

ST300

3059

114784

9

115835

550

116391

900

116540

800

116549

800

MS27039-08-11

Purchased

No

120

Each

67.0000

2

8



Screw

Location

Loc Qty

Loc Code

ST290

67

116289

67

Wednesday, January 26, 2011 10:54:43 AM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65806



Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

120

Each

51.0000

2

8



Screw



11/2/11 J@

Location

Loc Qty

Loc Code

ST292

51

114718

1

116169

50

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	*HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	*STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00